

Work Order ID 134666

July-14-15 3:12:49 PM

Page 1

PRELIMINARY ISSUE
134666

Item ID: D5283-043
Revision ID: PRELIM
Item Name: Basket Clamp Assembly

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Start Date: 14/07/2015 Start Qty: 2.00 *2*
Required Date: 16/07/2015 Req'd Qty: 2.00 *2*

Cust Item ID:
Customer:



Reference:

Approvals: Process Plan: *15-07-14* Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5283	<i>PA20 Rev A</i>

DAS 9 9-89

110 0.00
110
Bandsaw Memo D5283-043 0.00
Jeaspa Bandsaw CUT BLANK FOR D5283-5

2 0 15/07/15

120 Manufacture as per dwg 0.00
120
Mill Conv Memo D5283-043 0.00
Conventional Milling Machine MANUFACTURE D5283-5 AS PER DWG

2 0 3.C.2 15/07/15

130 QC2- Inspect parts off machine FAI/FAIB 0.00
130
QC Memo 0.00
Quality Control

2 0 3.C.2 15/07/15

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134666

Page 2

Item ID:	D5283-043	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:	PRELIM					
Item Name:	Basket Clamp Assembly				Stop	*NS2*
Start Date:	14/07/2015	Start Qty: 2.00	*2*	Cust Item ID:		
Required Date:	16/07/2015	Req'd Qty: 2.00	*2*	Customer:		
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									DAS
QC	Memo	0.00				<u>2</u>	<u>15-07-15</u>	<u>9</u>	<u>9-89</u>
Quality Control						as per	DS283-3		
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				<u>2</u>	<u>FF</u>	<u>JUL 16 2015</u>	
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160					DAS				
QC	Memo	0.00			30	<u>2</u>			<u>JUL 15 2015</u>
Quality Control					9-89				

Work Order ID 134666

134666

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July-14-15 3:12:49 PM

Item ID: D5283-043 Accept *N900040100* Setup Start *NS1*
Revision ID: PRELIM Stop *NS2*
Item Name: Basket Clamp Assembly
Start Date: 14/07/2015 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 16/07/2015 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170									
Powdercoat	Memo <i>11/13/15 45</i>	0.00							
Powder Coating	***MASK BEARING BORE PRIOR TO POWDER COAT***								
	START TIME: <i>8:40</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>9:10</i>								
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190									
Small Fab	Memo	0.00							
Small Fab	PRESS FIT BEARING AND STAKE 4 PLACES PER SIDE AS PER DWG								

2 *φ* *15-7-16* *DAS* *34* *9-89*

2 *FF* *JUL 16 2015*

2 *FF* *JUL 16 2015*

July-14-15 3:12:49 PM

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Item ID:	D5283-043	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:	PRELIM					
Item Name:	Basket Clamp Assembly				Stop	*NS2*
Start Date:	14/07/2015	Start Qty: 2.00	*2*	Cust Item ID:		
Required Date:	16/07/2015	Req'd Qty: 2.00	*2*	Customer:		
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

POSITIVE RECALL
 EFFECTIVE 15-03-14
 AUTH DATE 68-6
 RELEASED 68-6
 JUL 16 2015

Picklist Print

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Page 1

Work Order ID: 134666

134666

Parent Item: D5283-043

D5283-043

Parent Item Name: Basket Clamp Assembly

Start Date: 14/07/2015

Required Date: 16/07/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 15.07.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No				Each	25.0000		2		JUL 16 2015	
D2611									**		FF		
Bearing													

Location

Loc Qty

Loc Code

ST008A

25

131130

15

134006

10

M6061T6B1.500X04.00
0

Purchased

No

f

18.9500

10.52632

M6061T6B1 500X04 000

6061T6 Bar 1.500 x 4.00

**

Location

Loc Qty

Loc Code

MAT004

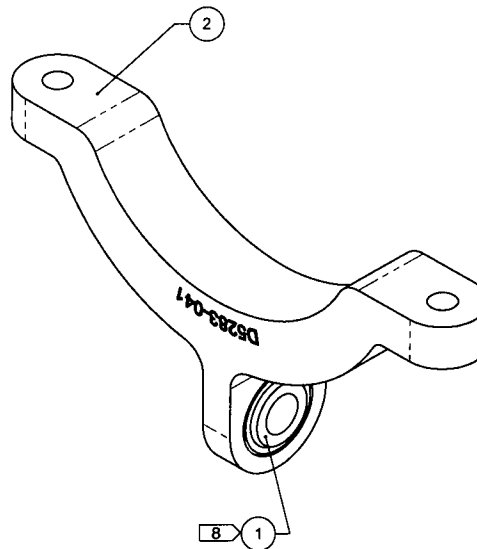
18.95

M126075

18.95

0.966'

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-041	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-1	BASKET CLAMP



D5283-041 BASKET CLAMP ASSY

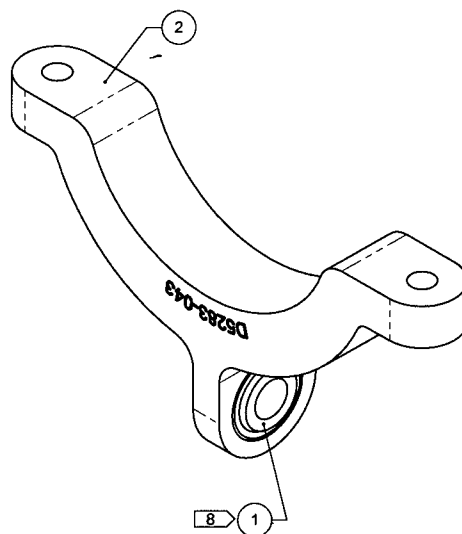
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

A	NEW ISSUE		DB	15.06.30
REV.	DESCRIPTION		BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DB			
CHECKED	AP	DRAWING NO.		REV. A2
MFG. APPR.	JLM	D5283		SHEET 1 OF 6
APPROVED		TITLE		SCALE
DE APPR.		BASKET CLAMP ASSY		NT
DATE	15.06.30	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

UNAPPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-043	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-3	BASKET CLAMP



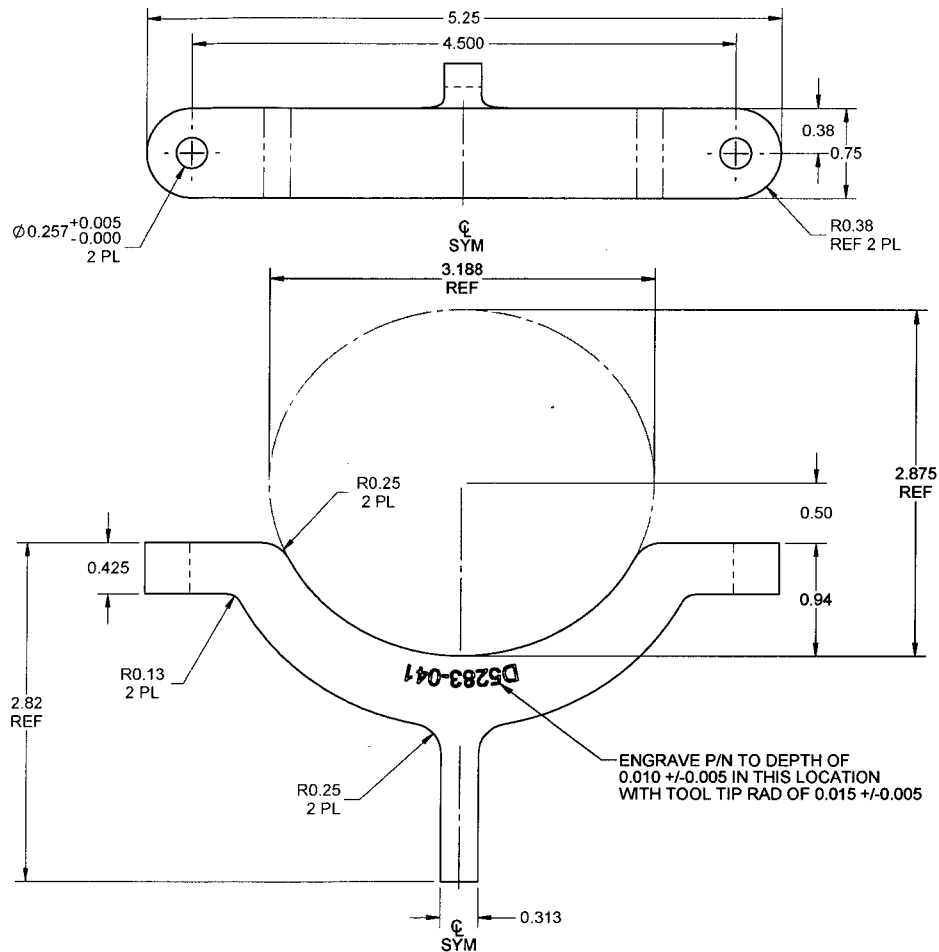
D5283-043 BASKET CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

UNAPPROVED

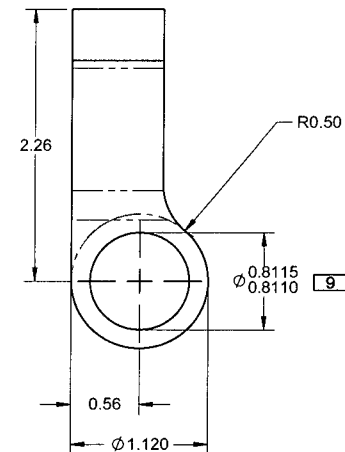
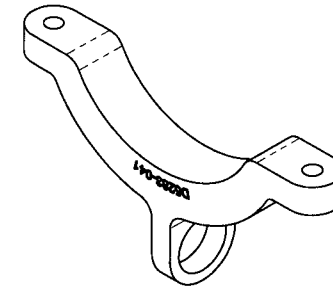
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D5283-1 BASKET CLAMP

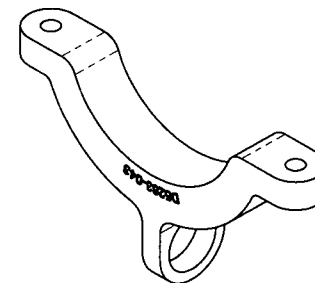
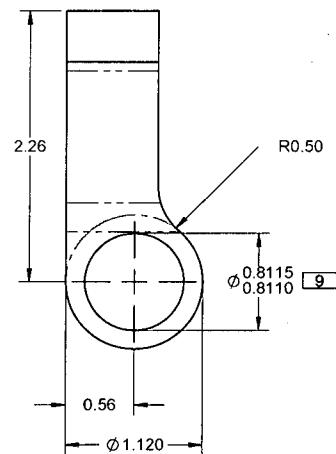
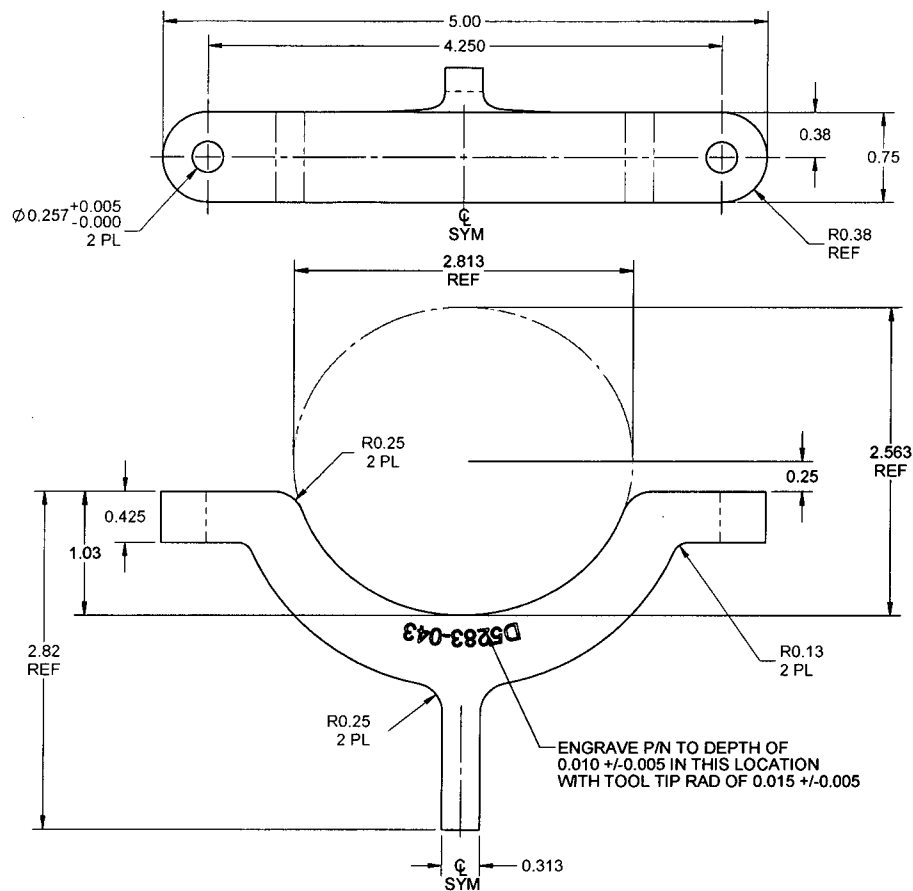
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-041 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-1.Rev A.STEP
- 9) MASK BEARING BORE PRIOR TO POWDER COAT



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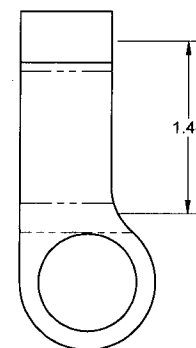
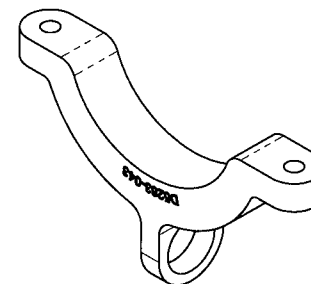
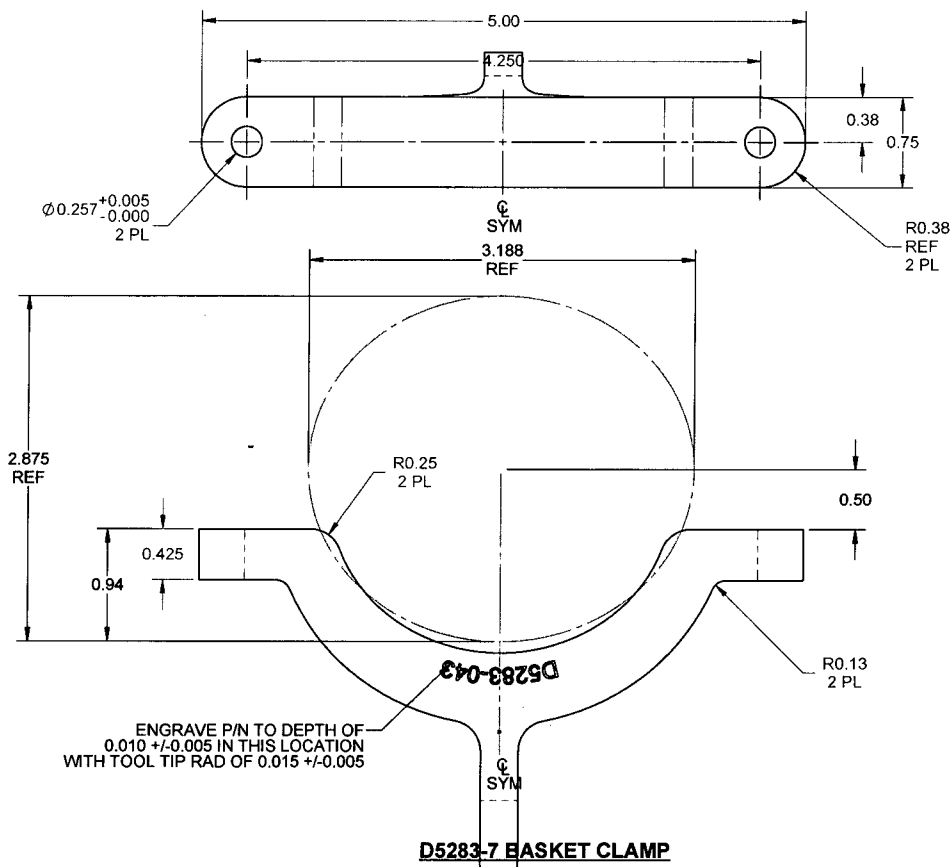
D5283-3 BASKET CLAMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-043 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-3.Rev A. STEP
- 9) MASK BEARING BORE PRIOR TO POWDER COAT

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CHECKED	AP	DRAWING NO.	REV. A20
MFG. APPR.	JLM	D5283	SHEET 4 OF 6
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DE APPR.		BASKET CLAMP ASSY	NTS
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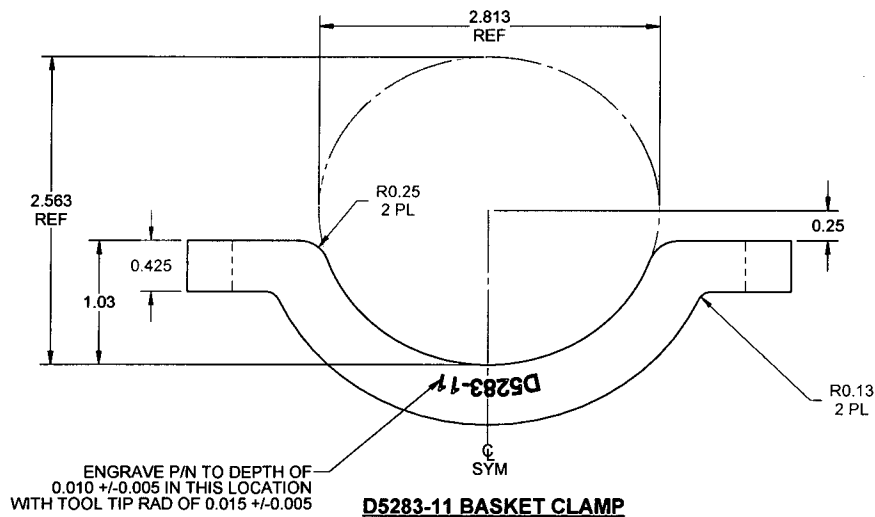
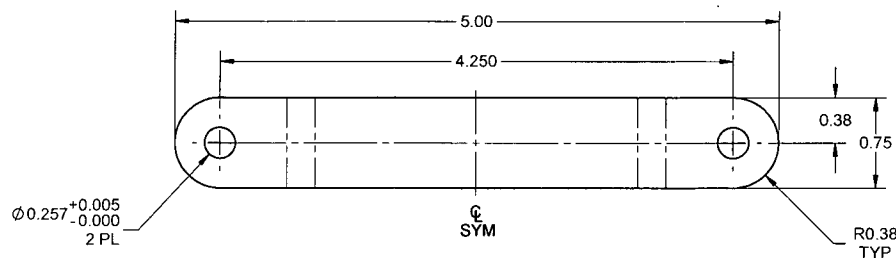


NOTES:

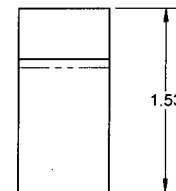
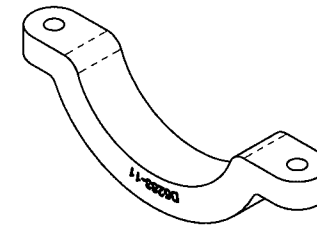
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-7 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-7.Rev A.STEP

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MFG. APPR.	JLM	D5283	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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D5283-11 BASKET CLAMP



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-11 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-11.Rev A STEP

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MFG. APPR.	JLM	D5283	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET CLAMP ASSY	NTS
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DART AEROSPACE LTD		Work Order: 134666
Description: Basket Clamp Assembly		Part Number: 115283-093
Inspection Dwg: 115283 Rev: A20		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+ 0.030	4.999	✓		Caliper	JCL-08
0.75	+ 0.030	0.750	✓		"	
0.38	+ 0.030	0.375	✓		"	
0.257	+ 0.005 - 0.000	0.258	✓		"	
2.82	+ 0.030	2.819	✓		H.G.	31006
1.03	+ 0.030	1.030	✓		"	
0.425	+ 0.010	0.427	✓		Caliper	JCL-08
0.313	+ 0.010	0.316	✓		"	
2.26	+ 0.030	2.2605	✓		H.G.	31006
0.56	+ 0.030	0.560	✓		Caliper	
1.120	+ 0.010	1.120	✓		"	
0.8110/0.8115		0.8115	✓		"	
R 0.13	+ 0.030	0.125	✓		Rad. Gauge	
R 0.25	+ 0.030	0.250	✓		"	
R 0.38	+ 0.030	0.375	✓		"	
R 0.50	+ 0.030	0.500	✓		"	

Measured by: S.L.-L.	Audited by:	Preliminary Approval:
Date: 18/07/18	Date:	Date:

Rev	Date	Change	Reviewed by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO20192**

Purchase Order Date 6/14/2013

PO Print Date 6/14/2013

Page Number 3 of 5

Order From :
RYERSON
200 DU CHEMINOT
VAUDREUIL, QUEBEC J7V 5V5

VC-RYS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-424-0153

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

7	M6061T6B1.000X12.000	6061-T6 Bar 1.00 x 12.00	6/19/2013	24.00	✓	\$626.58
	AS ABOVE		Yes 6/19/2013	f	<i>[Signature]</i>	

Line Total: \$626.58

8	M6061T6B1.500X01.500	6061-T6 Bar 1.50 x 1.50	6/19/2013	36.00	✗	\$176.22
	AS ABOVE		Yes 6/19/2013	f	<i>[Signature]</i>	

Line Total: \$176.22

9	M6061T6B1.500X04.000	6061T6 Bar 1.500 x 4.00	6/19/2013	24.00	✓	\$313.27
	AS ABOVE		Yes 6/19/2013	f	<i>[Signature]</i>	

Line Total: \$313.27

10	M6061T6B2.000X01.250	6061-T6 Bar 2.00 x 1.25	6/19/2013	12.00	✓	\$65.27
	AS ABOVE		Yes 6/19/2013	f	<i>[Signature]</i>	

Note:

6/14/2013

DART AEROSPACE LTD. P.O. - 20192 S.O. - 310685

KAISER ALUMINUM

FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
5205 KAISER DRIVE
KALAMAZOO, MI 49048

CUSTOMER PO NUMBER: 727773-1		CUSTOMER PART NUMBER: 51319499		PRODUCT DESCRIPTION: KAISERSELECT SC MANIFOLD BAR 1.50 X 4.00	
KAISER ORDER NUMBER: 633045	LINE ITEM: 001	SHIP DATE: 12/04/2012		KAISER LOT NUMBER: Z00212048	ALLOY: 6061
WEIGHT SHIPPED: 513.000 LB		QUANTITY: 6.000 PCS	B/L NUMBER: 605039	TEMPER: T6511B	
SHIP TO: RYERSON 161 THE WEST MALL ETOBICOKE, ON M9C4V8 CANADA		SOLD TO: RYERSON 161 THE WEST MALL ETOBICOKE, ON M9C4V8 CANADA		LENGTH: 12.000 FT	

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONDUCT.	BEND
Z00212048	0001	1	45.9	43.7	13.1	RE 95	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
102146	.74	.30	.28	.09	.93	.09	.03	.03	.00	.00	.00	.01	.03

Applicable Requirements:

MANIFOLD BAR, SPECIAL STENCIL PER ASTM-B221-12, STENCILED PER AMS-QQ-A-200/8 (2007)
ASME-SB221 1998 SECT. II MEETS ALL SPECIFICATION REQUIREMENTS FOR 6061-T6511/T6
ELEVATED MINIMUM MECHANICAL PROPERTIES AS FOLLOWS: UTS = 42.0 KSI MIN YIELD = 38.0 KSI
MIN ELONGATION = 10.0% MIN

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

Calvin Latting, Quality & Technology Manager

Calvin Latting

Plant Serial: 00069071
Kaiser Order Number: 633045
Line Item: 001

RYERSON

Shipping Order / Bordereau d'expédition

MO #

200 RUE DU CHEMINOT

200 RUE DU CHEMINOT

Phone/Tel (450) 424-0153

VAUDREUIL-DORION QC J7V 5V5

VAUDREUIL QC J7V 5V5

Sold to/Facteur a:

DART AEROSPACE LTD.

1270, ABERDEEN STREET

Ship to/Expédier a:

DART AEROSPACE LTD.

1270, ABERDEEN STREET

Page 3 de 5 06/19/13 17:54 CST

SO

AP

S.O. / Bordereau d'expédition

X6-310685

P.O. / Bon de commande

20192

HAWKESBURY

ON K6A 1K7

HAWKESBURY

ON K6A 1K7

Phone/Tel (613) 632-3336

Qty Shipped/Qté expédiée B.O. Qty/En souffrance

Line /# de ligne	Item	Description				
7	5131-9499	PLAT AL EXTRUDE 6061T6511 COIN CARRE 1 1/2 X 4	X 144			
		Tariff Code / Code tarifaire: 7604.29.00.19				
Qty Comm:	2	Order Qty/Qté commandée	2	UEA	Pcs: 2	2.00 UEA
(0 -PK/WI 169 LINE 1)						
		Cntrl: X6FL9657 C: Z00212048	T: Z00212048		1 pcs Loc EXP	
		Cntrl: X6FL9658 C: 201302069	T: 362889		1 pcs Loc EXP	
*** Filled by Initials/Rempli par initiale: MT						
8	5131-8871	PLAT AL EXTRUDE 6061T6511 COIN CARRE 1 1/4 X 2	X 144			
		Tariff Code / Code tarifaire: 7604.29.00.19				
Qty Comm:	1	Order Qty/Qté commandée	1	UEA	Pcs: 1	1.00 UEA
(0 -PK/WI 35 LINE 1)						
		Cntrl: X6FL8812 C: Z00247012	T: Z00247012		1 pcs Loc EXP	
*** Filled by Initials/Rempli par initiale: MT						
9	5131-9341	PLAT AL EXTRUDE 6061T6511 COIN CARRE 1 1/2 X 3	X 144			
		Tariff Code / Code tarifaire: 7604.29.00.19				
Qty Comm:	1	Order Qty/Qté commandée	1	UEA	Pcs: 1	1.00 UEA
(0 -PK/WI 64 LINE 1)						
		Cntrl: X6FM3298 C: Z00649008	T: Z00649008		1 pcs Loc EXP	
*** Filled by Initials/Rempli par initiale: MT						

Customer/Driver Instructions / Commentaires du client/chauffeur:

HEURES D'OUVERTURE 7H @ 16H LUN @ VEND DECHARGEMENT AU CHARIOT ELEVATEUR AVANT COTE CHAUFFEUR
CFC ET MTR REQUIS A LA LIVRAISON

Packing List/Bordereau de marchandises

Received by/ Reçu Par:

Date:

Acceptance of goods constitutes acceptance of our Terms and Conditions, available on our website at www.Ryerson.com, or from your sales representative, or by calling (800) 268-2680.L'acceptation des marchandises constitue un consentement à nos termes et conditions, qui sont disponibles sur notre site web www.ryerson.com, ou par votre représentant interne, ou par téléphone (800) 268-2680.

Alloys of Aluminum, Copper, Steel Caution:

Processing of this material may present a physical and or health hazard. See material safety data sheets for further information

Les alliages d'aluminium, de cuivre, d'acier Avertissement:
Le Traitement de ce matériel peut présenter un risque physique et ou pour la santé. Pour de plus ample information voir les fiches.

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-RYS001	Ryerson Canada								
PO20192	8		M6061T6B1.500X01. f 500		6/19/2013	6/20/2013	36.0000	\$4.72	0.0000	0	\$169.96
CAD	No		6061-T6 Bar 1.50 x f 1.50		36.0000	DESJ02		\$169.96	0.0000	0	
			M126075								
	9		M6061T6B1.500X04. f 000		6/19/2013	6/20/2013	24.0000	\$12.59	0.0000	0	\$302.15
	No		6061T6 Bar 1.500 x f 4.00		24.0000	DESJ02		\$302.15	0.0000	0	
			M126075								
	10		M6061T6B2.000X01. f 250		6/19/2013	6/20/2013	12.0000	\$5.25	0.0000	0	\$62.95
	No		6061-T6 Bar 2.00 x f 1.25		12.0000	DESJ02		\$62.95	0.0000	0	
			M126075								
	11		M6061T6B30000X01 f .500		6/19/2013	6/20/2013	12.0000	\$9.44	0.0000	0	\$113.31
	No		6061-T6 Bar 3.00 x f 1.50		12.0000	DESJ02		\$113.31	0.0000	0	
			M126075								
	12		M6061T6S.063 : sf		6/19/2013	6/20/2013	336.0000	\$1.89	0.0000	0	\$633.82
	No		6061-T6 .063 Sheet sf		320.0000	DESJ02		\$633.82	0.0000	0	
			M126075								
	13		M6061T6S.125 sf		6/19/2013	6/20/2013	32.0000	\$3.91	0.0000	0	\$125.22
	No		6061-T6 .125 Sheet sf		32.0000	DESJ02		\$125.22	0.0000	0	
			M126075								
	14		M304S11GA sf		6/19/2013	6/20/2013	192.0000	\$7.29	0.0000	0	\$1,400.45
	No		304/316 0.125 Sheet sf		192.0000	DESJ02		\$1,400.45	0.0000	0	
			M126075								
	15		M304S14GA sf		6/19/2013	6/20/2013	128.0000	\$4.46	0.0000	0	\$570.98
	No		304SS sheet .080 sf		128.0000	DESJ02		\$570.98	0.0000	0	
			M126075								

Total Received Quantity: 952.0000

Total Qty to Inspect (PO U/M): 0.0000

Total Reject Quantity: 0.0000

Total Receipt Value: \$4,607.24

Total Balance Due Quantity: 0.0000

Work Order ID 131130

March-26-15 1:44:02 PM

131130

Page 1

Item ID: D2611

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearing

Stop ***NS2***

Start Date: 3/26/15 Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLD Date: 15-03-31 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2611	Rev C								

100 PURCHASING 0.00

100

Purchasing

Memo 0.00

Purchasing

Issue P/O: 27963 Purchase part as per Dwg D2611 Possible supplier:
McMasterP/N: 63215K34 Material release note required

CL 15/03/31 40

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Memo 0.00

Packaging

Ensure certificate of conformity is attached

40X 5015-01-2

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Memo 0.00

Quality Control

40

DAS
38

APR 06 2015

Work Order ID 131130

131130

Page 2

March-26-15 1:44:02 PM

Item ID: D2611 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearing
 Start Date: 3/26/15 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>STORA</u>	0.00				40	DAS 27		
130	Packaging Memo	0.00							
	Packaging								
									APR 07 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140	QC Memo	0.00							
	Quality Control								

ML5 1504-07

15.47

Picklist Print

March-26-15 1:44:02 PM

Page 1

Work Order ID: 131130

131130

Parent Item: D2611

D2611

Parent Item Name: Bearing

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:B99.06.23Re-formatDM
Change to SS; Change Supplier- Rev.C 07.03.14 EC

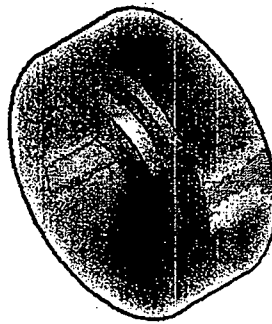
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
63215K34		Purchased		No			Each	0.0000		40			
63215K34									**				
Bearing													

40x SPIS-04-2

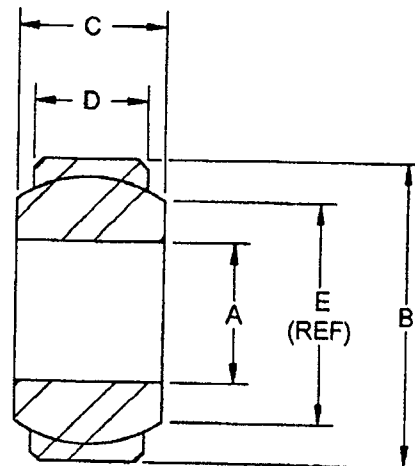
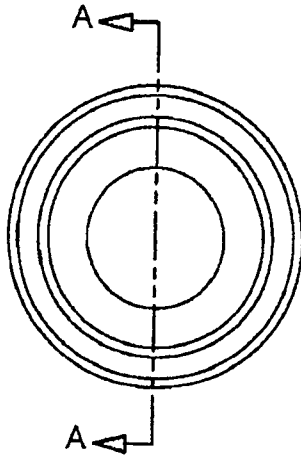


DESIGN 90	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2611	REV. C SHEET 1 OF 1
DATE 06.09.20		TITLE BEARING	SCALE NTS
REV	DATE	DESCRIPTION	
A	97.07.31	NEW ISSUE	
B	01.07.04	RE-DRAWN	
C	06.09.20	CHANGE TO SS, CHANGE SUPPLIER	

SPECIFICATION CONTROL DRAWING



RELEASED
06.11.17 H



SECTION A-A

UNCONTROLLED
NO 131130 MCT
1503-31

A	B	C	D	E (REF)	POSSIBLE SUPPLIER
0.375	0.813	0.406	0.313	0.592	McMASTER-CARR P/N 63215K34

NOTES:

- 1) STAINLESS STEEL BALL JOINT SWIVEL BEARING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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RT
SPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27963

Purchase Order Date 3/31/2015

PO Print Date 3/31/2015

Page Number 3 of 4

Order From :
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 330 995 5500

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency USD
FOB FCA - (Free Carrier)

6	63215K34	Bearing	4/1/2015	40.00	✓	\$17.24	(\$689.60)
			Yes 4/1/2015	Each			

AS PER DWG D2611 REV. C
B131130

Spis al-2
Line Total:

\$689.60

7	71550-11	9198K16 303 ROUND BAR 5" DIA	4/1/2015	1.00		\$154.08	\$154.08
			Yes 4/1/2015	Each			

1 PCS OF 3 FT

Line Total: \$154.08

Deliver To: JEAN-LUC

8	71400-40	19525T13 HIGH TEMPERATURE CASTER	4/1/2015	4.00	✓	\$23.53	\$94.12
			Yes 4/1/2015	Each			

Line Total: \$94.12

Deliver To: LUC

Note:

3/31/2015



Packing List

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Deliver To Luc

Purchase Order
PO27963

Order Placed By
Chantal Lavoie

McMaster-Carr Number
1428983-01

Page 1 of 1

03/31/2015

Line	Product	Ordered	Shipped
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer	1 Each	1 ✓
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10	5 Packs	5 ✓
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	8 Each	8 ✓
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25	2 Packs	2 ✓
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1 ✓
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick	40 Each	40 ✓
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long	1 Each	1 ✓
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity Your Part Number: 71400-40	4 Each	4 ✓
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc Your Part Number: 71400-40	4 Each	4 ✓

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8037 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 26682794
Purchase Order: PO27963
Release:
McMaster-Carr Number: 1428983-01

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 31-Mar-2015 FOB: ORIGIN
Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

Forwarding Agent:

Billing
Attention:
Shipping Deliver To Luc
Attention:
Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer Country of Origin: United States Schedule B #: 400821 ECCN #: EAR99 NLR	1 EA	\$102.55	\$102.55
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10 Country of Origin: Taiwan Schedule B #: 731816 ECCN #: EAR99 NLR	5 PK	\$3.83	\$19.15
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	8 EA	\$17.14	\$137.12
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 Country of Origin: Taiwan Schedule B #: 731822 ECCN #: EAR99 NLR	2 PK	\$6.66	\$13.32
Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department. These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.				

Shipping Weight (In kgs): 21

Number of Packages: 1

Invoice Amounts:

Merchandise Amount: \$1,284.06
Total (In USD): \$1,284.06

Package Dimensions:

64 X 33 X 34 CM = .071 CUBIC M

Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days

Authorized Signature:

Date:

31-Mar-2015

Remit payment to:
(by mail)
McMaster-Carr Supply Company
PO Box 7690
Chicago, IL 60680-7690 USA

(by wire transfer)
Bank of America Illinois
231 S LaSalle
Chicago, IL 60697
ABA 071000039 Account 86666-02021
SWIFT BOFAUS3N

Name: Sarah Weinberg

Title: Operations Mgr.

Page 1 of 2

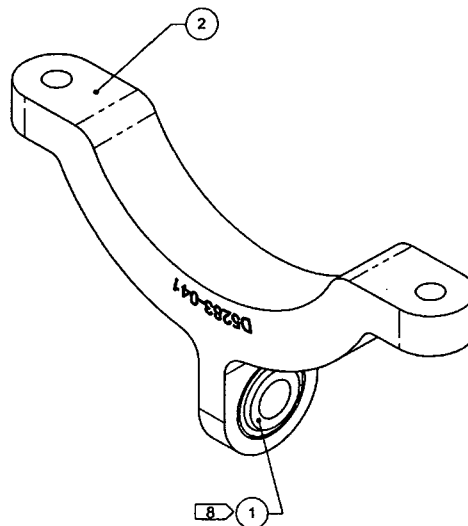
McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 26682794
 Purchase Order: PO27963
 Release:
 McMaster-Carr Number: 1428983-01

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.60	\$8.60
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	40 EA	\$17.24	\$689.60
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long Country of Origin: Sweden Schedule B #: 722211 ECCN #: EAR99 NLR	1 EA	\$154.08	\$154.08
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$23.53	\$94.12
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc, 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$16.38	\$65.52
NOTE Tracking number(s) for this shipment: 633862298275				
Number of Packages: 1				

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-041	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-1	BASKET CLAMP



D5283-041 BASKET CLAMP ASSY

NOTES:

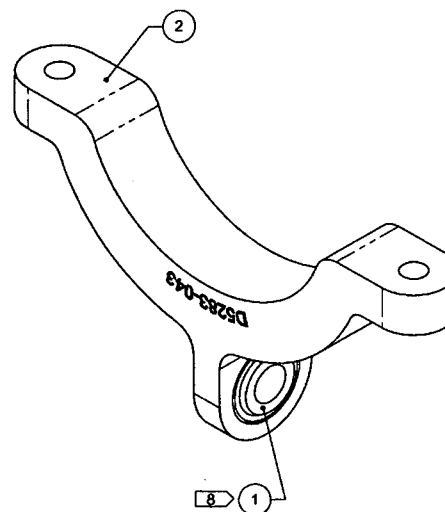
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

RELEASED
2015-07-20
ERN 15-607

A	NEW ISSUE	DB	15.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
DATE	15.06.30	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
	-043		
	X	D5283-043	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-3	BASKET CLAMP



D5283-043 BASKET CLAMP ASSY

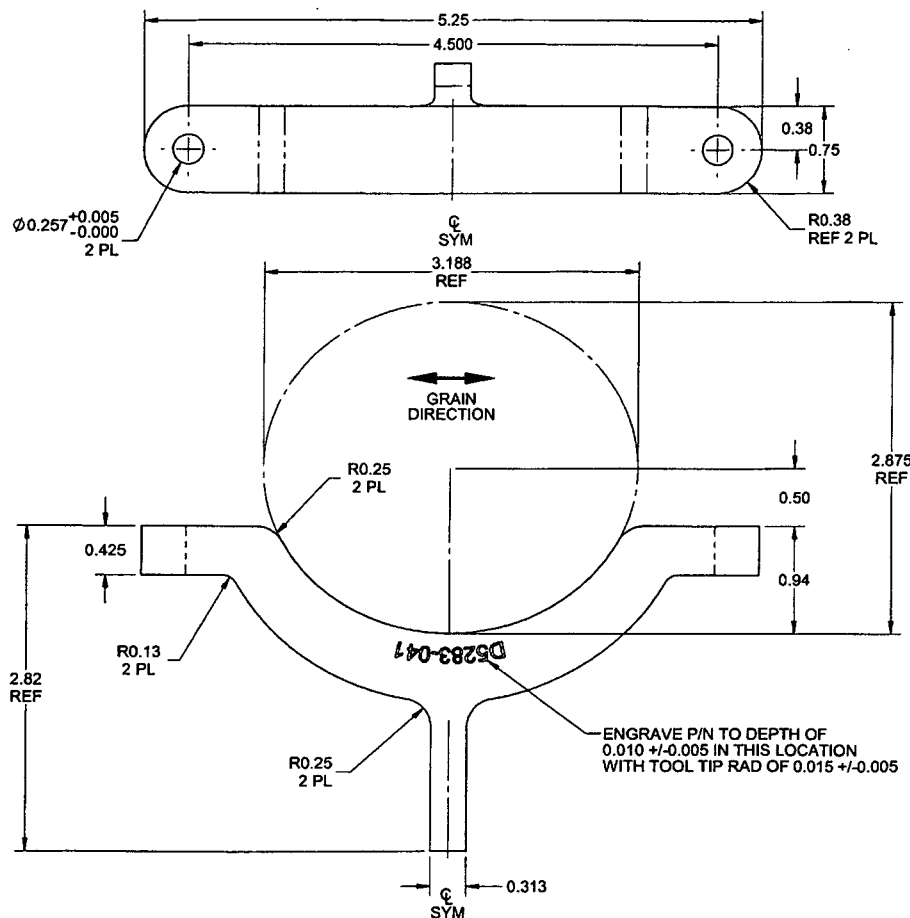
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 2 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
DATE	15.06.30	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

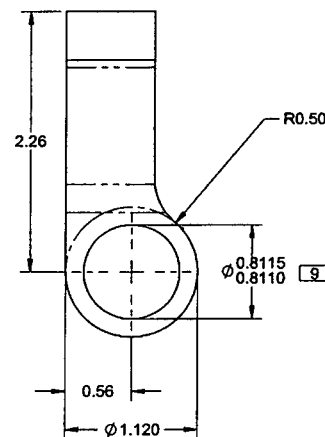
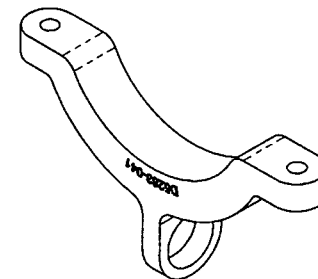
RELEASED
2015-07-20



D5283-1 BASKET CLAMP

NOTES:

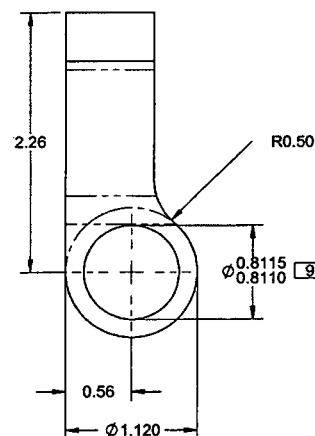
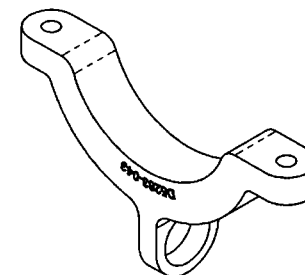
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-041 PER QSI 044 6.3
- 7) WEIGHT: 0.24 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-1.Rev A.STEP
- 9) MASK BEARING BORE PRIOR TO POWDER COAT



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CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5283	SHEET 3 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
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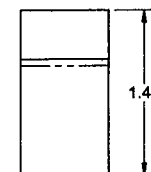
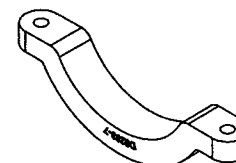
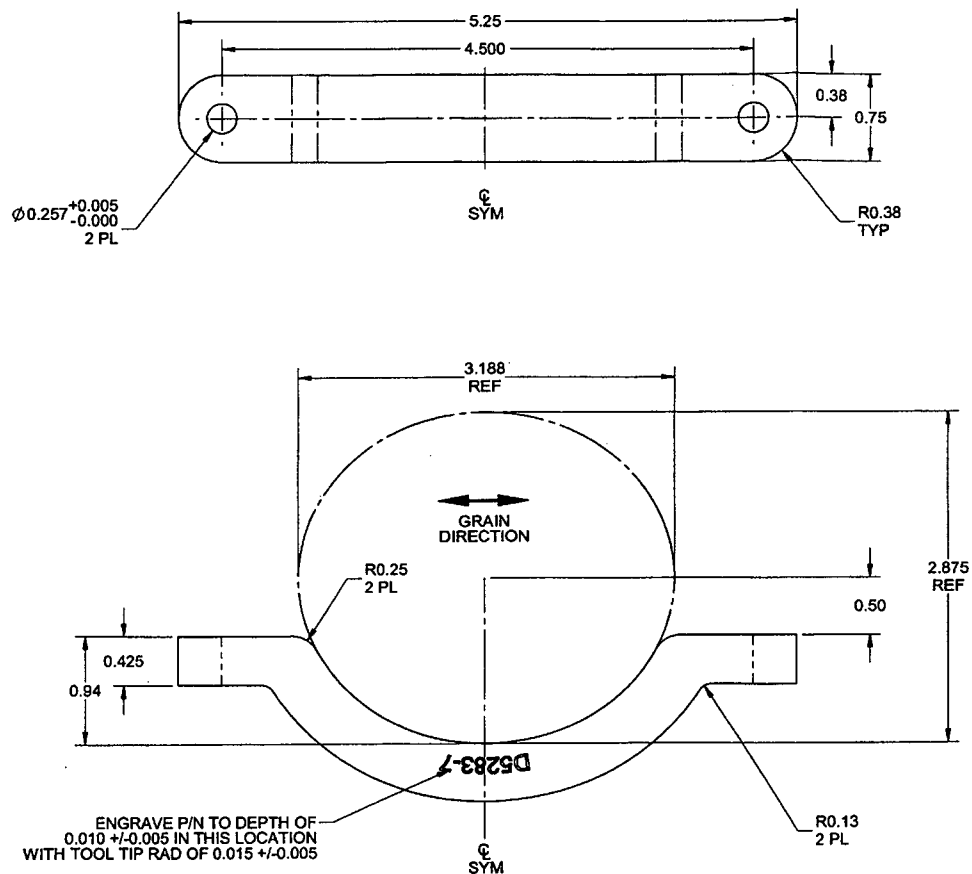


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NOTES:

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MFG. APPR.	JLM		SHEET 4 OF 6
APPROVED	WM		SCALE
DE APPR.	DS		BASKET CLAMP ASSY
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D5283-7 BASKET CLAMP

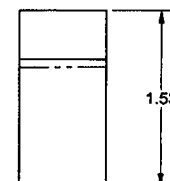
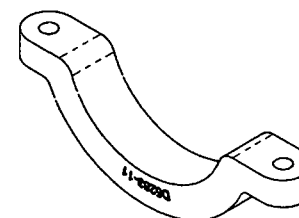
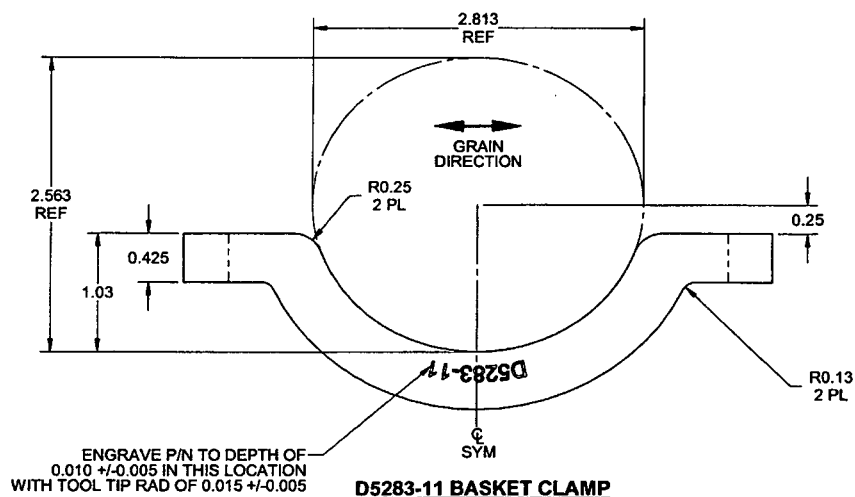
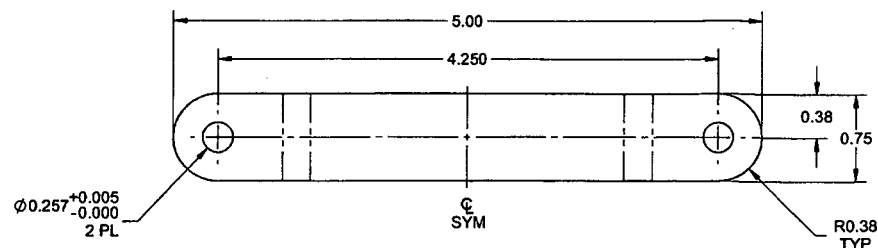
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-7 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-7.Rev A.STEP

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MFG. APPR.	JLM	D5283	SHEET 5 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET CLAMP ASSY	NTS
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NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6081T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-11 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-11.Rev A.STEP

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MFG. APPR.	JLM	D5283	SHEET 6 OF 6
APPROVED	WM	TITLE	SCALE
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